

Work Order ID 64496

Wednesday, April 20, 2011 1:18:14 PM



DUPLICATE

Page 1

Item ID: D206-802-029

Accept



Setup Start



Revision ID:

Stop



Item Name: Crew Door Opener Installation, LH

Start Date: 12/7/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/20/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-04-20 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D407-802-3	A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-802-029 CHG001

Sulachro

JGAS BG 11-4-20

105

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

JB C 11/04/20

110

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Sulachro



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 12/7/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 12/20/2010 Req'd Qty: 2.00

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	Packaging	0.00				11/4/20	sf	20	
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPDD206-802-029 Location: _____ PPP rev: <u>DORP</u>								
130 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11-04-20

W/O:		WORK ORDER CHANGES					
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[illegible]

Required Qty: 2.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-15 		Manufactured	No			105	Each	33.0000	1	2	✓		
Door Prop													
				<u>Location</u>									
				ST272				21					
				64402				21					
				ST272A				12		64402			
				65119				12					
D3622-5 		Manufactured	No			105	Each	60.0000	1	2	✓		
Ball Stud													
				<u>Location</u>									
				ST070				60					
				64330				20		64330			
				64428				20					
				65087				20					
D4110-3 		Manufactured	No			105	Each	13.0000	1	2	✓		
Doubler, Sill													
				<u>Location</u>									
				ST130				13					
				64356				8		64356			
				64788				5					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order #D: 64496

Parent Item: D206-802-029

Parent Item Name: Crew Door Opener Installation, LH

Start Date: 12/7/2010

Required Date: 12/20/2010

Start Qty: 2.00

Required Qty: 2.00

D4114-1

Manufactured No

105 Each

4.0000

1

; 2 ✓

Door Doubler, LH

Location

Loc Qty

Loc Code

ST130

4

64498

4

105

Each

5,895.000

4

8 ✓

MS20426AD4-5

Purchased

No

Rivet

Location

Loc Qty

Loc Code

MEZZ

535

6733

535

ST317

5360

6874

5360

105

Each

468.0000

32

64 ✓

MS20600-AD4W2

Purchased

No

Rivet

Location

Loc Qty

Loc Code

ST321

468

114348

8

116391

100

116471

60

116805

100

117317

200

114348 fx

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 64496

Parent Item: D206-802-029

Parent Item Name: Crew Door Opener Installation, LH

Start Date: 12/7/2010

Required Date: 12/20/2010

Start Qty: 2.00

Required Qty: 2.00

MS21073L5

Purchased

No

105

Each

159.0000

2

4

✓



nut plate

Location

Loc Qty

Loc Code

ST302

100

117395

100

ST303

59

113660

39

116583

20

113660

NAS1149C0532R

Purchased

No

105

Each

372.0000

6

12

✓



WASHER

Location

Loc Qty

Loc Code

ST297

372

116289

72

116373

100

116513

200

116289

NAS1149C0563R

Purchased

No

105

Each

598.0000

6

12

✓



Washer

Location

Loc Qty

Loc Code

ST297

598

112532

100

115768

98

116391

200

117460

200

115768

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Picklist Print

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Parent Item: D206-802-029



Parent Item Name: Crew Door Opener Installation, LH

Start Date: 12/7/2010

Required Date: 12/20/2010

Start Qty: 2.00

Required Qty: 2.00

MS27130-A26

Purchased

No

105

Each

81.0000

1

2

✓



Rivnut

JB 11/04/20

Location

Loc Qty

Loc Code

ST293

81

116521

81

116521

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5.0 PARTS LIST

5.1 D206-802-029/-030 Crew Door Opener Kits

Qty -029	Qty -030	Part Number	Description
1		D206-802-029	CREW DOOR OPENER KIT, LH
	1	D206-802-030	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
1	1	D3622-5	BALL STUD
1	1	D4110-3	DOUBLER, SILL
1		D4114-1	DOOR DOUBLER, LH
	1	D4114-2	DOOR DOUBLER, RH
4	4	MS20426AD4-5	RIVET
32	32	MS20600AD4W2	RIVET
2	2	MS21073L5	ANCHOR NUT
1	1	MS27130-A26	RIVNUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.2 D206-802-031/-032 Passenger Door Opener Kits

Qty -031	Qty -032	Part Number	Description
1		D206-802-031	PASSENGER DOOR OPENER KIT, LH
	1	D206-802-032	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	2	D3622-5	BALL STUD
	1	D4112-1	AFT SILL DOUBLER
1	1	D4115-5	DOUBLER
1		D4115-041	LITTER DOOR BRACKET ASSY
3		CR3242-5-4	RIVET
2		CR3243-5-4	RIVET
2	4	MS20426AD4-5	RIVET
9	14	MS20600AD4W2	RIVET
1	2	MS21073L5	ANCHOR NUT
3	6	NAS1149C0532R	WASHER
3	6	NAS1149C0563R	WASHER